



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3319-1
Job Sheet 174301



Part No: D3319-1

Job Qty: 12 ea

Part Name: Forward Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 3/13/18

Job Tracking No:

Due Date: 3/22/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC IPP Rev:C Now on Waterjet 06-10-26 JLM IPP REV:D
17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	3/21/18	3/21/18	0.00	0.00	Start Up Waterjet		SE 18/03/18
100	Waterjet	12 pcs	3/21/18	3/21/18	0.00	1.25	Waterjet1		SE 18/03/18
110	QC	12 pcs	3/21/18	3/21/18	0.00	0.00	QC2 Waterjet-2		SE 18/03/18
120	QC	12 pcs	3/21/18	3/21/18	0.00	0.00	QC8-2		38
140	Brake NC	12 pcs	3/21/18	3/21/18	0.07	0.87	Brake NC 1		38
150	QC	12 pcs	3/21/18	3/21/18	0.00	0.00	QC5		38
160	Autoweld 1	12 pcs	3/21/18	3/21/18	0.00	3.08	Automated welding		DAS 18/03/18
170	QC	12 pcs	3/21/18	3/21/18	0.00	0.00	QC10		38
180	QC	12 pcs	3/21/18	3/21/18	0.00	0.00	QC5		38
190	SprayPaint	12 pcs	3/22/18	3/22/18	0.00	0.28	Spray Paint		SP 18/03/18
200	QC	12 pcs	3/22/18	3/22/18	0.00	0.00	QC3		11
210	Packaging	12 pcs	3/22/18	3/22/18	0.00	0.00	Packaging3-1		9-89
220	QC21-SA	12 Ea	3/22/18	3/22/18	0.00	0.00	QC21		21

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary
Descriptions: 140 - 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: _____ 2- Form flat on press using D1806 block
160 - 8259 HARDCOAT B: 5024335
190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.
BATCH: 138819
210 - Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	7.5360 sf (.628 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	8	110	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval				
				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Dart Aerospace Ltd. 1270 Aberdeen Street Hewitsonbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 02/14/18 Container No: S051016 Part: D3319-1 Job No: 174301 Serial No/Batch: S051016 Revision: D Inspector: Environ D Doc/ Equip/To Handling Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified								
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:25%;"> Use for testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due </td> <td style="width:25%;"> Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter </td> <td style="width:25%;"> Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes </td> <td style="width:25%;"> REGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> </tr> </table>					Use for testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due	Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	REGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
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OTHER :								

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	4.980inches $\pm$ 0.030	5.010 4.950	4,979	
2	Wearplate	1.600inches $\pm$ 0.010	1.610 1.590	1,608	
3	Wearplate	2.660inches $\pm$ 0.010	2.670 2.650	2,665	
4	Wearplate	3.190inches $\pm$ 0.010	3.200 3.180	3,180 3,188	
5	Wearplate	3.563inches $\pm$ 0.010	3.573 3.553	3,565	
6	Wearplate	4.710inches $\pm$ 0.030	4.740 4.680	4,712	
7	Wearplate	0.600inches $\pm$ 0.030	0.630 0.570	0,598	
8	Wearplate	10.576inches $\pm$ 0.010	10.586 10.566	10,577	
9	Wearplate	11.942inches $\pm$ 0.010	11.952 11.932	11,943	
10	Wearplate	18.090inches $\pm$ 0.030	18.120 18.060	18,092	
11	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315	0,317	
12	Wearplate	0.546inches $\pm$ 0.010	0.556 0.536	0,547	
13	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315	0,317	
14	Wearplate	0.670inches $\pm$ 0.010	0.680 0.660	0,672	
15	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189	0,191	
16	Wearplate	3.815inches $\pm$ 0.010	3.825 3.805	3,816	
17	Wearplate	16.100inches $\pm$ 0.010	16.110 16.090	16,100	

Plex 3/13/18 1:28 PM dart.lacelle.linda

DQA: _____ Date: _____



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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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